

Date: Friday, 16/01/2009 10:00:47 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : RIB ASSY  
 Job Number : 44872  
 Estimate Number : 13667  
 P.O. Number :  
 This Issue : 16/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D3852042  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3852 REV A  
 Previous Run : 44023 Project Number : N/A  
 Material :  
 Due Date : 23/01/2009 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : JWD 09.01.16  
 Comment : Est Rev:A 08-12-02 new issue DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D37591 Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

batch: B44057 SD 09.01.22

2.0 D31663 Basket Hoop



Comment: Qty.: 0.1890 Each(s)/Unit Total : 0.3780 Each(s)

Basket Hoop

batch: B44051 SD 09-01-19

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig
- 2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852
- 3- c'sink hole as per dwg
- 4- remove identification markings
- 5- deburr

SD 09-01-19 2

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 09/01/20 (17)

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: M108775 SD 09.01.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 16/01/2009 10:00:47 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY

Job Number: 44872

Part Number: D3852042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- grind bushing weld flush as per dwg D3852  
3- deburr hole if necessary

SP 09.01.21.

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 05-01-22 (2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/01/22 (x2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Basket c.

PD 09-01-22 (2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/26 dg

Job Completion



W 09.01.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

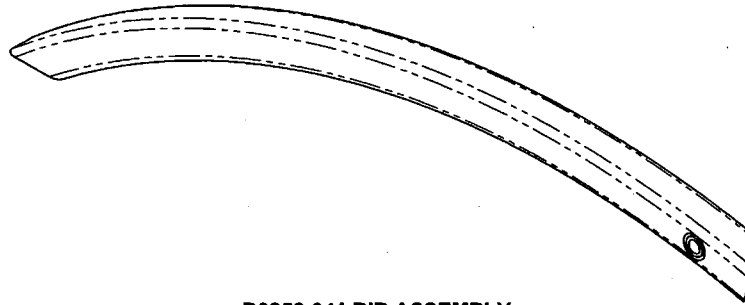
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

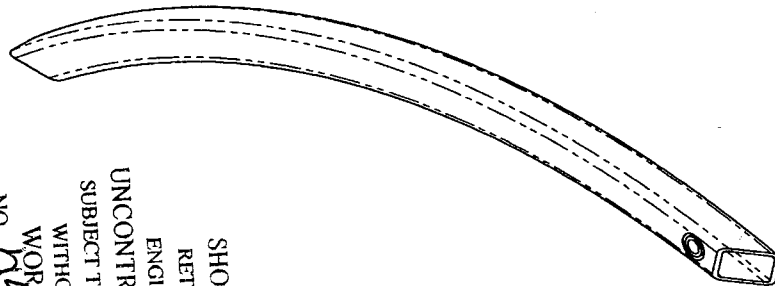
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB



**D3852-041 RIB ASSEMBLY**



**D3852-042 RIB ASSEMBLY**

RELEASED  
08/11/08 MP

NO. 14812  
WORK ORDER  
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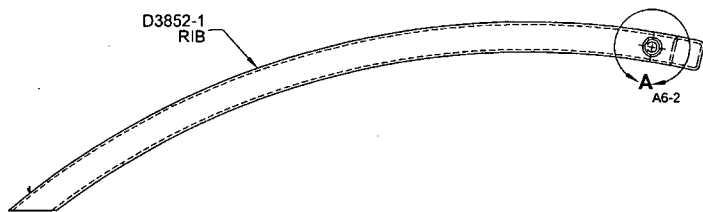
- NOTES:**  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.83 lbs EACH  
8) WELDING: PER QSI 004

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

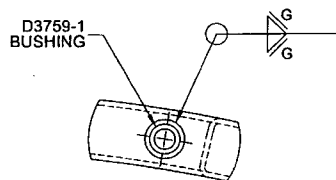
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3852	SHEET 1 OF 3
TITLE	RIB ASSEMBLY	SCALE NTS
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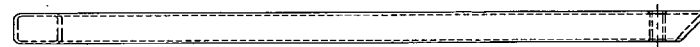
D3852-1  
RIB



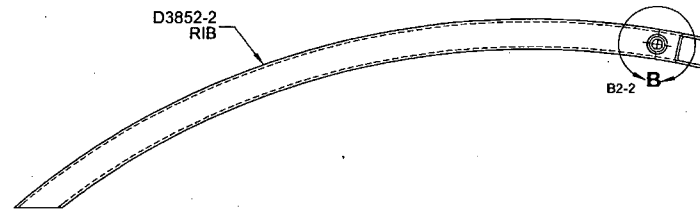
**D3852-041 RIB ASSEMBLY**



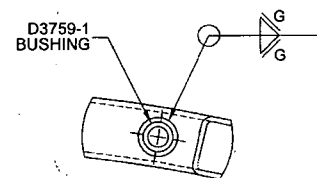
**DETAIL A**  
SCALE 2X C5-2



D3852-2  
RIB



**D3852-042 RIB ASSEMBLY**

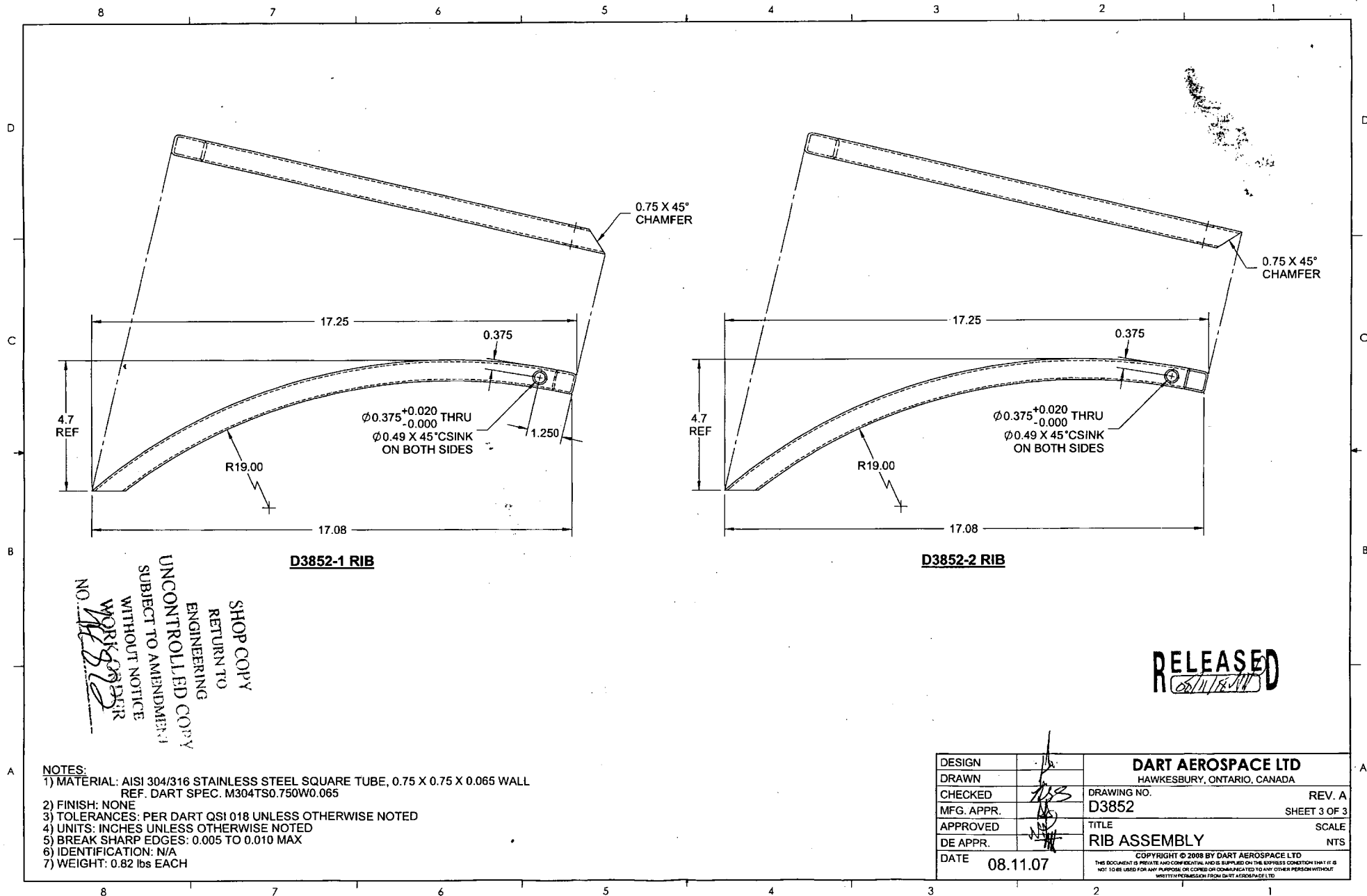


**DETAIL B**  
SCALE 2X C2-2

**RELEASED**  
08/11/07

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CHECKED	125	DRAWING NO. <b>D3852</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSEMBLY</b>	NTS
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WORK ORDER  
NO 44872



**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

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